

Date: Tuesday, 8/28/2007 3:22:54 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	HINGE BRACKET	
Job Number	34310				
Estimate Number	10348				
P.O. Number	N/A		Part Number	D28581	
This Issue	8/28/2007 S.O. No. : N/A		Drawing Number	D2858 REV B	
Prsht Rev.	NC		Project Number	N/A	
First Issue	N/A		Drawing Revision	B	
Previous Run	31698		Material	N/A	
Written By			Due Date	9/30/2007	
Checked & Approved By	<u>KJ 07.08.28</u>		Qty:	24 Um: Each	
Comment	Est C 08.06.22 Removed P/O for powder coat EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B1500X01250	6061-T6 Bar 1.5" x 1.25"	
		Comment: Qty.: 0.1767 f(s)/Unit Total : 4.2412 f(s) Material: 1.50" X 1.25" 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8) (M6061T6B15001250) Batch <u>M104182</u>	
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks 6.02" Note: 1 Blank Makes 3 Parts	<u>SD</u> 07.10.21
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine per folio D2858-	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>SD</u> 07.10.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/06/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/28/2007 3:22:54 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 34310

Part Number: D28581

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/10/22 (39)

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

M/A 07/10/23

7.0 QC5

INSPECT WORK TO CURRENT STEP



N/A 07/10/23

Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(39X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

M/L

07/10/25

9.0 POWDER COATING

POWDER COATING



(39X)

M105068

Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

M/L

07/10/25

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



M/L

Comment: INSPECT POWDER COAT

07-10-25

x 39

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock ST51

Location: B34310

07/10/26

18

(39X)

12.0 QC21

FINAL INSPECTION/W/O RELEASE



(39)

Comment: FINAL INSPECTION/W/O RELEASE

D 07/10/06

Job Completion



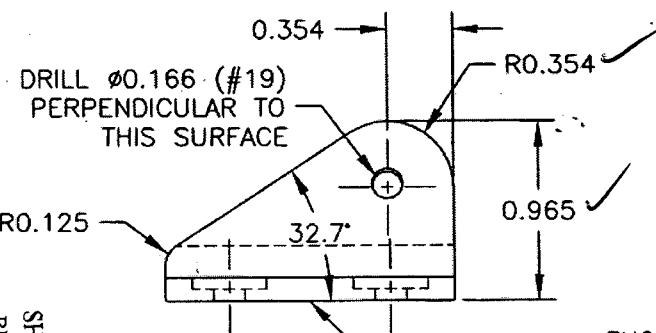
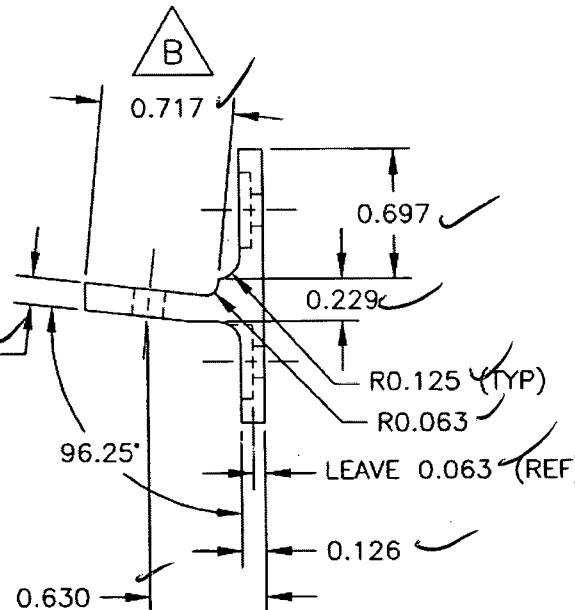
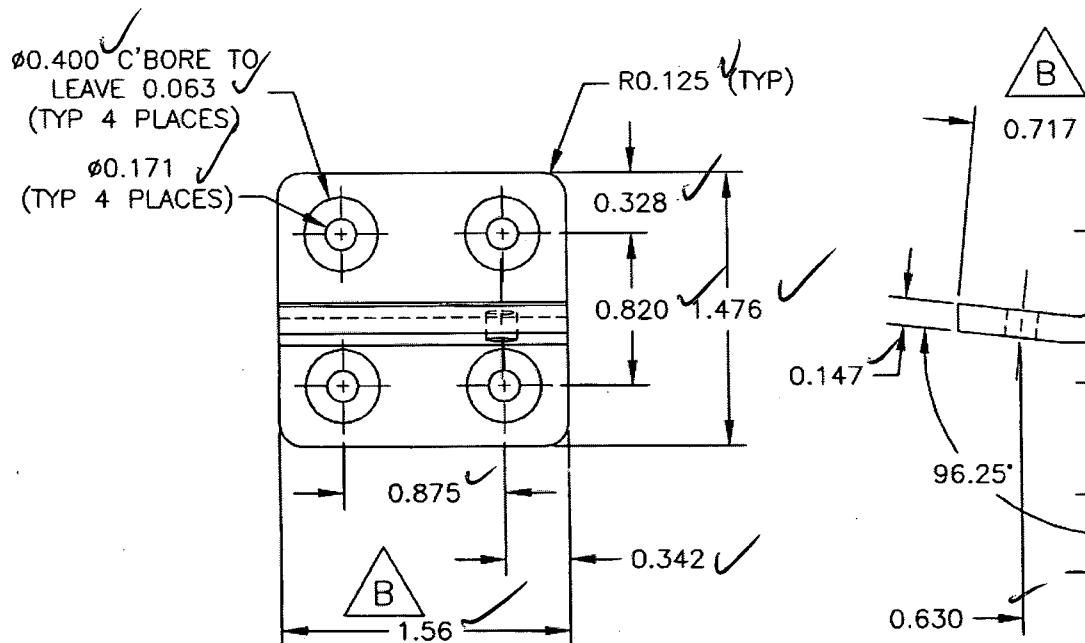
U 07/10/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ENGRAVE P/N CENTERED ON
BASE 0.003 DEEP (0.010 MAX)

D2858-1 SHOWN
D2858-2 OPPOSITE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
99.02.09 KEL

DART

QA COPY
99.02.09 KEL

DESIGN	DRAWN BY	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
UP	JM	D2858	
DATE			
A	98.12.14	NEW ISSUE	
B	99.02.28	0.717 WAS 0.667, 1.56 WAS 1.559	
SCALE			
SHEET 1 OF 1			

DART AEROSPACE LTD

Work Order:

Description: HINGE BRACKET

Part Number:

D2858-1

Inspection Dwg:

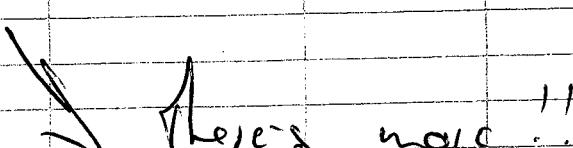
Rev:

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.400	.393	.399	/			
Ø.171		Ø.171	/			
R.125		R.125	/			
.328	+.010	.332	/			
.820	-.010	.820	/			
1.476	+.010	1.485	/			
.875	+.010	.876	/			
.342	-.010	.343	/			
1.56	+.030	1.566	/			
.147		.147	/			
.717		.715	/			
.697		.697	/			
.229		.235	/			
R.125		R.125	R.125			
R.063		R.063	R.063			
.063		.063	/			
.126		.126	/			
.630		.631	/			



There's more!!

Spec'd by:	SD
Date:	07.10.22

Audited by:	J.P.
Date:	07/10/22

Prototype Approval:	
Date:	

Ref	Date	Change	Revised by	Approved
		New Issue	KJ/RF	



DART AEROSPACE LTD	Work Order:	
Description:	Part Number:	D2858-1
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	SD	Audited by:	S.F.	Prototype Approval:	
Date:	07/10/22	Date:	07/10/22	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	